

Work Order ID 71371 -1

Thursday, June 30, 2011 8:20:13 AM



Page 1

Item ID: D2965

Accept



Setup Start



Revision ID:

Item Name: Cap, 105 Skidtube

Stop



Start Date: 6/30/2011 Start Qty: 50.00

Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 50.00

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2965

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14401
Required

Cast per Dwg D2965 Material Release Note

CL 11/06/30 50

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

11/11/10 (50)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Subtotal

Count

450

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Drill as per Dwg D2965 with DT8538 Deburr and Tumble

0.00

0.00

SP 11/08/15 (48)

140



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

5 wlog/15

counted (48)

150



Powdercoat

Powder Coating

Powdercoat

Memo

Mask as per Dwg D2965 Powder To match Skidtube (Ref: 4.3.5.x) as per QSI 005 4.3 START TIME: 10:45 FINISH TIME: 3200F

0.00

0.00

48x Ø M-L 11/08/18 38

M 117745

10:45

3200F

Q

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

38 4 11-8-23

170

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Install Inserts as per Dwg D2965

38 4 11-8-23

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11-8-23

counts
38

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 71371

Thursday, June 30, 2011 8:20:13 AM



Page 4

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Setup Start



Revision ID:

Stop



Item Name: Cap, 105 Skidtube

Start Date: 6/30/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 50.00



Customer:

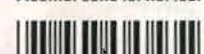
Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Identify as per dwg & Stock Location: *FP-5*

0.00

Memo

0.00

Packaging

*38**BR 11-8-23*

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/8/23**MF**11-08-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 30, 2011 8:20:10 AM

Page 1

Work Order ID: 71371

Parent Item: D2965

Parent Item Name: Cap, 105 Skidtube



Start Date: 6/30/2011

Required Date: 7/15/2011

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: A ☐ 00.05.31 ☐ New Issue ☐ EC

IPP Rev: Added Turning as per Rev B 06-12-15 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225

Purchased

No

170

Each

700.0000

2

100



INSERT

Location

ST282

100896

111529

111581

Loc Qty

700

100

300

300

Loc Code

D2965P

Purchased

No

170

Each

0.0000

1

50



Cap

Handwritten notes:
 100896
 x76
 P4/18/08 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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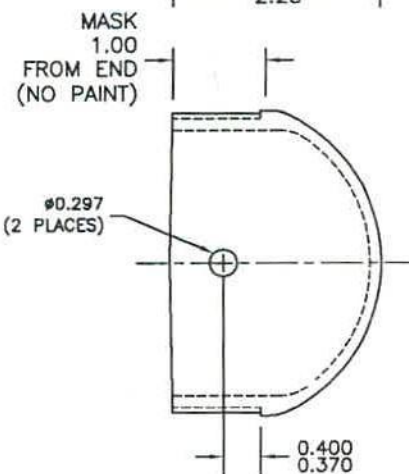
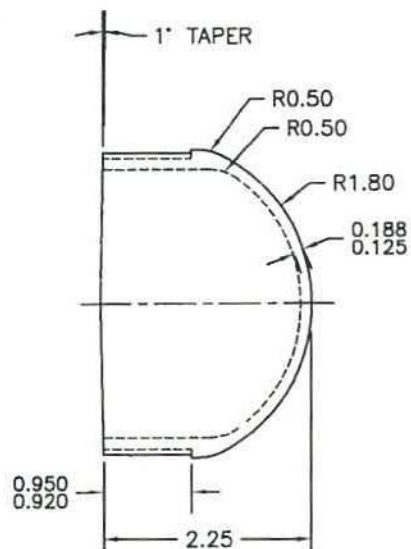
NOTE: Date & initial all entries

DART

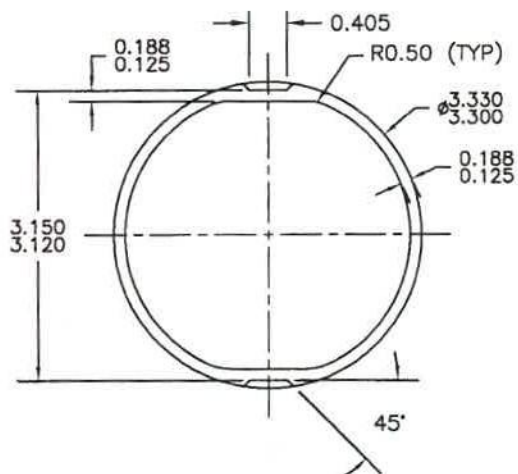
RELEASED

06.12.12

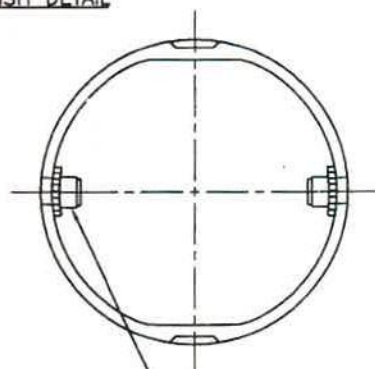
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
014	014	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
06.11.01	00.02.24	D2965	SHEET 1 OF 2
DATE		TITLE	SCALE
06.11.01		CAP	1:2
A	00.02.24	NEW ISSUE	
B	06.11.01	ADD -3 CAP	

021106130
W10: 71371

D2965 CASTING DETAIL



D2965 FINISH DETAIL

INSTALL AELS-1032-225 INSERT
(2 PLACES)

D2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

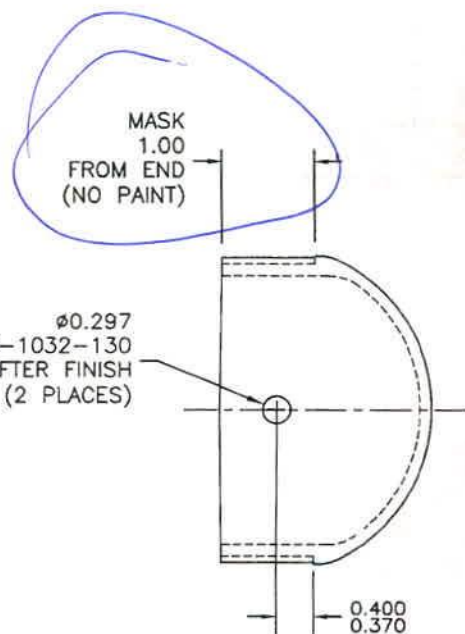
NOTE: Date & initial all entries

DART

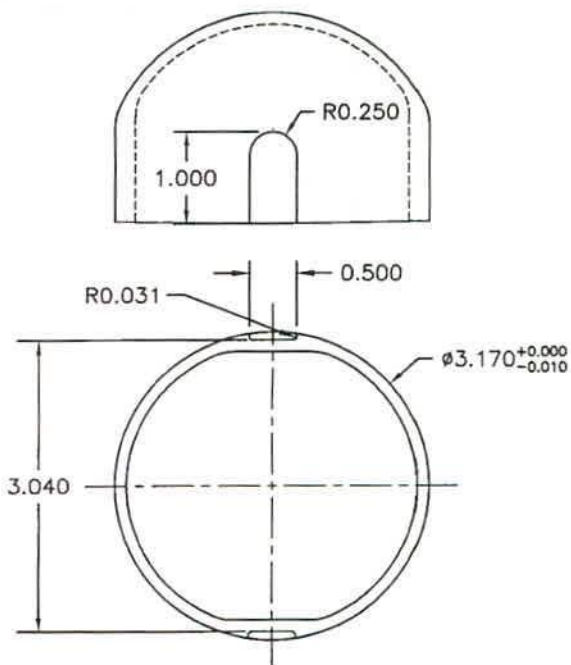
DESIGN	AW	DRAWN BY	AW	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA			
CHECKED	AW	APPROVED	AW	DRAWING NO.	REV. B
DATE	06.11.01			D2965	SHEET 2 OF 2
				TITLE	SCALE
				CAP	1:2

RELEASED

06.12.02



D2965-3 FINISH DETAIL

D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART
aerospaceDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14401

Purchase Order Date 6/30/2011

PO Print Date 6/30/2011

Page Number 1 of 1

Order From : VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name

Vendor Phone 514 683 9777

Vendor Fax 514 683 0375

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

REVISEDShip To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAX 613 632 1053

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2965P	Cap	7/18/2011 Yes	50.00 Each	FedEx PI collect	\$20.3500	\$1,017.50

Special Inst: CAST AS PER DWG D2965 REV. B
B71371MATERIAL: CAST ALUMINUM
ALLOY A356.2 (F)

PO Total: \$1,017.50

MATERIAL CERTIFICATION
REQ'D UPON DELIVERYCERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 6/30/2011

Aluminum Foundry Ltd

2225 Chemin St. Francois
Dorval, Québec H9F 1K3
Tel: (514) 683-9777
Fax: (514) 683-0375
email: info@foundryafpw.com

Packing Slip

Packing Slip No.: 33764
Shipped Date: 03 08 2011

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 14401	
Shipped By:	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z200080	Each	D2965 CAP	50
<div>Received by:</div> <div>Date:</div>			
Comment:			

7CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD2225 CHEMIN ST. FRANCOIS, DORVAL, QC H9P-1K3
TEL : (514) 683-9777 FAX: (514) 683-0375Attn. Chantal
Corrected
addressExpédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: 03/08/2011 Slip No. 33764

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 14401
Your order No.

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
50	D 2965 CAP Sudorlos	Z200080	A356.2	ingot#855862 B# 1120401

Analyse
Analysis (as in Ingot)

(Si)	7.1%	(Al)	balance
(Fe)	0.09%		
(Cu)	0.03%		
(Mn)	0.00%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.13%		

Donne
Yield :Résistance à la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per :

Coc-100

7 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3
TEL: (514) 631-1331 FAX: (514) 631-8448Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Date: 03/08/2011 Packing Slip No. 33764

Hawksbury, ON, K8A 1K7

Vôtre No. Commande 14401
Your order No.

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50	D 2965 CAP	Z200080	A356.2	ingot#855862 B# 1120401

Analyse
Analysis (as in Ingot)

(Si)	7.1%	(Al)	balance
(Fe)	0.09%		
(Cu)	0.03%		
(Mn)	0.00%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.13%		

Donne
Yield :Résistance à la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per :

Coc-100